

Work Order ID 57169

March 24, 2010 12:21:46 PM

Page 1

Item ID: D2512

Accept

Revision ID:

Item Name: Basket Lid 205/350

Start Date: 24/03/2010 Start Qty: 1.00

Required Date: 31/03/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date: 10-3-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100

Weld per dwg A/R S.S. rod Batch: M109213 0.00

Large Fab

Large Fab

Memo

0.00

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512 - PD
2-Cut (4) D2236 From D3166-3 - 8 S.A.D. 10-03-31
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305 - PD
4-Weld as per Dwg D2512 using Welding Jig DT 9436
Deburr as required
INSTALL D2012-117 CLEVIS ONLY ON D130-701-041

PD 10.04.02

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Memo

0.00

Quality Control

Pl 10.04.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2512

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Setup Start



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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

8/10/04/02



QC

Memo

0.00

Quality Control



130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME: 2:30

OVEN TEMPERATURE: 400 OF

FINISH TIME: 3:00

2ND COAT:

START TIME: 3:10

OVEN TEMPERATURE: 400 OF

FINISH TIME: 3:40

M113170

M-H 10/04/02



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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



HandFinish

HandFinishing

Memo

M 113991 spray paint

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch:

MH 3462 wing walk

M 112594 spray paint

M-H 10/04/03



150

0.00



QC

QC3- Inspect Part Finish

Memo

0.00

Quality Control

ES 10/04/05 (D)

160

0.00



Packaging

Identify as per dwg & Stock Location:

C-A

Memo

0.00

Packaging

ES 10/04/05 (D)

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/06

BS 10-4-5
①

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Picklist Print

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Page 1
4

Work Order ID: 57169



Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 24/03/2010

Required Date: 31/03/2010

Comments: Rev IPP:M 03.01.31 Added D2012-117 for D130-701-041 KJ/RF
 IPP Rev:N 06.04.05 Added level21 EC
 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2012-117 Manufactured No 100 Each 41.0000 2.0000



Clevis

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
WA	41	
31101	2	
52498	9	
55729	30	

N/A

*** ONLY APPLICABLE ON D130-701-041 -IF NOT USED, PLEASE MARK N/A ***

D2232-1 Manufactured No 100 Each 40.0000 2.0000



Basket Hinge

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
WA	40	
48230	2	
55791	38	

PD 10.03.31

D2327-1 Manufactured No 100 Each 27.0000 2.0000



Spacer Bushing

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
WA	27	
52832	7	
54658	20	

PD 10.03.31

W/O:		WORK ORDER CHANGES					
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 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2506 Manufactured No 100 Each 6.0000 1.0000



Label Plate



Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA 6

44275 1

55700 5

D2581 Manufactured No 100 Each 35.0000 2.0000



Mounting Bracket



Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA 35

46086 2

48428 1

50872 1

51120 2

51745 2

55918 27

PD 10.04.01

PD 10.03.31

W/O:		WORK ORDER CHANGES					
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 IPP Rev:N 06.04.05 Added level21 EC
 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3166-3 Manufactured No 100 Each 16.8103 1.0000



Basket Hoop



SAD 10-03-30

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA	16.81031447
48429	5
52058	1.4474E-05
55697	5.8103
56426	6

M304EX0.75-16F Purchased No 100 sf 1,081.944 18.9474



Expanded Metal Flat SS



SAD 10-03-31

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT	1081.944806
111956	0.000017
112147	9.4736E-06
112949	19.84438
113205	0.0093
113497	0.1449
113555	649.5873
113904	92.3589
114212	320

18,9474

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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IPP Rev:N 06.04.05 Added level21 EC
IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC
IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Date: 24/03/2010

Required Date: 31/03/2010

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

638.1112 45.8741



304 SQ Tube .75x.75x.065W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

638.1111759

112398

0.0000047

113082

0.00419

113245

8.40038421

113683

0.30855

113836

0.000047

113956

29.398

114137

600

PD 10.03.31

March 24, 2010 12:21:51 PM

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Page 4

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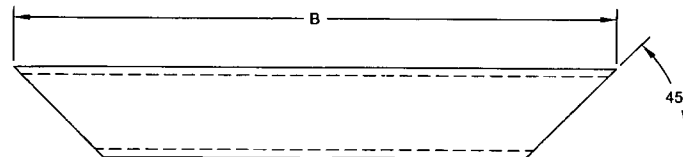
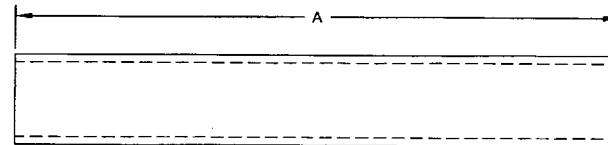
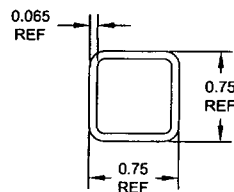
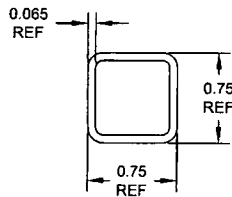
NOTE: Date & initial all entries

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57147
12-0-3-24

RELEASED
08-08-21-11



D2512-11/31-51-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS. INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D2512	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

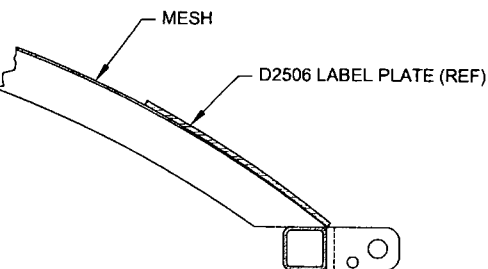
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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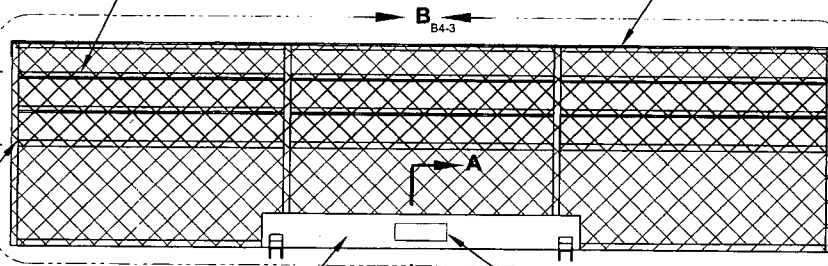
SECTION A-A_{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED

SKIN OUTSIDE SURFACE OF LID WITH
3/4-16F EXPANDED SS. TACK WELD
EACH END STRAND TO FRAME

SEE DETAIL B FOR
FRAME ASSEMBLY



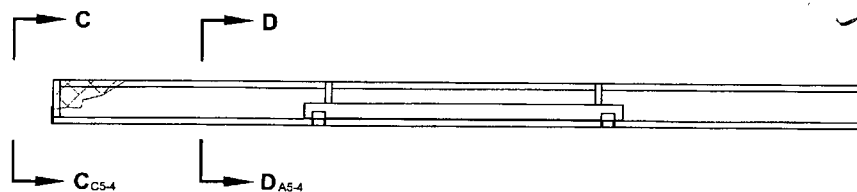
D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE



D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



57169

RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

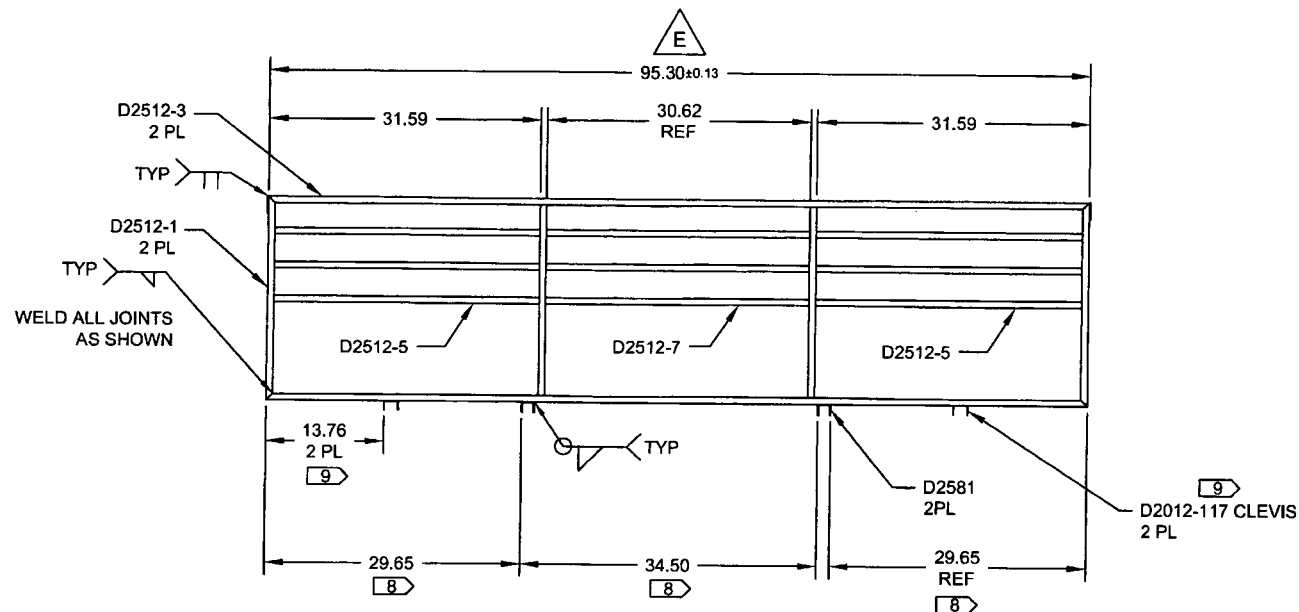
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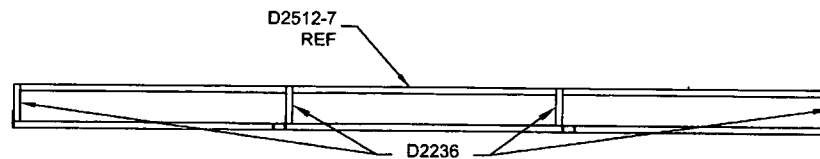
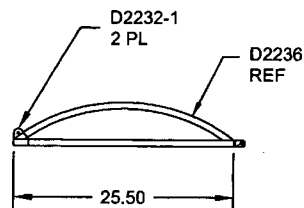
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DETAIL B _{C3-2}
FRAMEWORK ONLY SHOWN FOR CLARITY



NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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52169

RELEASED
08.06.17

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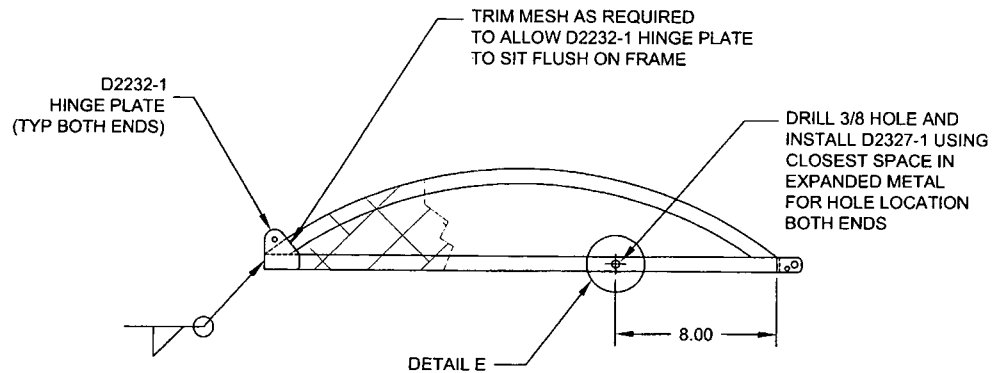
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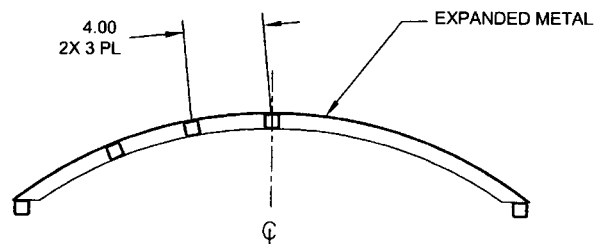
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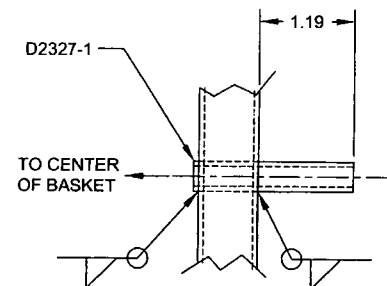
8 7 6 5 4 3 2 1



VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2



DETAIL E C6-4

57169

RELEASED
6806 21/100

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries